

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014937**Date Inspected:** 13-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr.An Qing Xiang/Qiu wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed

IN PROCESS INSPECTION:-

Trail Assembly Area:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SA164C/F-12 located on Doubler strut plate at 65M elevation. Welder is identified as 040365. ZPMC CWI is identified as Mr. Qiu wen. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2a-2.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: NSD1-SA166C/F-11 located on Doubler strut plate at 65M elevation. Welder is identified as 040582. ZPMC CWI is identified as Mr. Qiu wen. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2a-2.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WSD1-SA340B/F-16 located on Doubler strut plate at 53M elevation. Welder is identified as 040690. ZPMC QC is identified as Mr.Fu wei min. The welding variables recorded by QC appeared to comply with the WPS-B-T-4313-TC-P4.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector witnessed final Bolt tension verification for the Lift 1 North Tower 9M and 13M Diaphragm. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed as per the ZPMC submitted Notification No. 00377, dated: June 13, 2010. Details of bolt size, RC Set # and final torque value are as follows:

Bolt size used is M16X50, RC Set# DHGM160026 and final torque value was 193 N-m/260 N-m (turn nut/bolt head respectively). Manual Torque wrench is used with serial number noted as XO2-777.

Bay#11:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ESD1-SPSA5-20-2A located on Lift 5 Interior Splice Plate. Welder is identified as 040611. ZPMC QC is identified as Mr. Xu Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ESD1-SPSA5-7-3B located on Lift 5 Interior Splice Plate. Welder is identified as 046709. ZPMC QC is identified as Mr. Xu Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WSD1-SPSA5-2-1B located on Lift 5 Interior Splice Plate. Welder is identified as 046769. ZPMC QC is identified as Mr. Xu Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

Bay#10:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SPSA5-6-1A located on Lift 5 Interior Splice Plate. Welder is identified as 050266. ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: NSD1-SPSA5-6-4A located on Lift 5 Interior Splice Plate. Welder is identified as 044511. ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: NSD1-SPSA5-19-2B located on Lift 5 Interior Splice Plate. Welder is identified as 050289. ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng- 159-2184-5703 , who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Pandaram

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer